

Dulux Zincanode 402 Zinc Primer

AUDI0539

Specifications	Approved to APAS 2916, AS/NZS 3750-9 Type 2
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Description
Two pack zinc rich epoxy primer

Features And Benefits	
<ul style="list-style-type: none"> Overcoat with epoxies, polyurethane and chlor rubbers without special techniques Economical and user friendly epoxy zinc coating Provides excellent corrosion protection 	<ul style="list-style-type: none"> Rapid dry and overcoat times Suitable for use in environments up to 200°C

Uses
<p>ZINCANODE 402 is a two-pack epoxy zinc rich primer designed to provide exceptional corrosion resistance in harsh exposures by sacrificial methods. ZINCANODE 402 is recommended for use over abrasive blast cleaned steel surfaces in most harsh environments, especially where overcoating is required without special mist or seal coat techniques.</p> <p>ZINCANODE 402 offers ease of application, high film builds without mud-cracking and exceptional adhesion to field weld areas cleaned by power sanding or power wire brushing. It is specified for use in power generation plants, bulk handling equipment and oil refineries. Also in mining and chemical processes, offshore structures and exposed pipelines.</p>

Performance Guide			
Weatherability	Epoxy coatings may yellow with time. On exterior exposure some chalking may also occur. This will not detract from the protective properties of the coating. Use a weatherable topcoat if required for appearance.	Salts	Excellent resistance to neutral and alkali salts when suitably topcoated.
Heat Resistance	Up to 200°C dry heat.	Water	Suitable for immersion in fresh and salt water when suitably topcoated.
Solvents	Resists splash and spillage of aromatic hydrocarbon solvents and most common alcohols.	Abrasion	Very good when fully cured.
Acids	Not recommended for acid conditions.	Alkalis	Do not use in strongly alkaline conditions unless suitably topcoated.

Typical Properties			
Classification	Zinc Rich Epoxy Primer	Finish	Matt
Colour	Grey Green	Components	2
Flash Point	Base 32°C, Hardener 25°C	Pot Life	8 Hours (25°C)
Shelf Life	12 months minimum @ 25°C	Mixing Ratio (V/V)	Part A : 4 Part B : 1
Thinner	DULUX Epoxy Thinner (920-08925)	Suitable Substrates	Abrasive blast cleaned steel
Line/Shade	<ul style="list-style-type: none"> 730-81386 Part A 976-63033 Hardener 	Topcoats	Single and two pack Dulux products
Product Code	PC 122		
Meets GBCA VOC Requirement?	N/A		
Application Methods	Other: Conventional, airless spray or air assisted spray. Brush and roller for small areas.		
Application Conditions		Min	Max
	Air Temperature	10	45
	Substrate Surface Temperature	10	45
	Relative Humidity	0	85
Solids By Volume	48		
	Min	Max	Recommended
Wet Film Per Coat (microns)	125	167	156
Dry Film Per Coat (microns)	60	80	75
Recoat Time (min)	5 Hours	Indefinite	
Theoretical Spread Rate (m²/L)	6.4	5.3	6.4

Hardener Details						
Drying characteristics at 75 microns dry film thickness						
Temperature	Touch	Handle	Full Cure	Recoat Min	Recoat Max	
10° C	2 Hours	17 Hours	7 Days	17 Hours	Indefinite	
15° C	2 Hours	10 Hours	7 Days	10 Hours	Indefinite	
25° C	1 Hour	5 Hours	7 Days	5 Hours	Indefinite	
Values are at 50% Relative Humidity						
TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD			A spreading rate of 6.4 sq. metres per litre corresponds to 75 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and condition of application and surface roughness			
Hardener Section Footer	# These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying. To overcoat after the maximum time has elapsed, either with itself or with another product, may require the surface to be abraded in order to ensure adequate adhesion. * When used for immersion conditions the maximum overcoat interval is 3 days.					

Typical Systems

Typical System STEEL

Preparation Guide Steel generally: Abrasive blast AS1627.4 Class 2.5
Steel for immersion service: Abrasive blast to AS1627.4 Class 3.0

Coat	Product	Spread Rate (m ² /L)	WFT (micron)	DFT (micron)
1st Coat	Zincanode 402	6.4	155	75
2nd Coat	Ferreko No 3	6.0	170	100
3rd Coat	Ferreko No 3	6.0	170	100
Minimum System DFT				275

Typical System STEEL

Preparation Guide Steel generally: Abrasive blast AS1627.4 Class 2.5

Coat	Product	Spread Rate (m ² /L)	WFT (micron)	DFT (micron)
1st Coat	Zincanode 402	6.4	155	75
2nd Coat	Duremax GPE - Pc255	5.7	175	125
3rd Coat	Weathermax HBR	7.0	145	100
Minimum System DFT				300

Notes Above figures are for standard hardeners and no Weathermax HBR Accelerator.

Typical System STEEL IN MILD AND INTERIOR ENVIRONMENTS

Preparation Guide Steel generally: Abrasive blast AS1627.4 Class 2.5

Coat	Product	Spread Rate (m ² /L)	WFT (micron)	DFT (micron)
1st Coat	Zincanode 402	6.4	155	75
2nd Coat	Luxathane R	9.0	110	50
Minimum System DFT				125

Surface Preparation

Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Rust, millscale, oxide deposits and old paint films on metal surfaces must be removed by abrasive blast cleaning to a minimum of AS1627.4 Class 2.5. Immersed steel must be prepared to AS1627.4 Class 3.

Application Guide

Application Method	Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes. Ensure the clean-up solvent is available before commencing application. Remix thoroughly before using and continue mixing during application.
Brush/Roller	For small areas only. Apply even coats of the mixed material to the prepared surface. Thinning is not normally required, however, up to 50ml/litre of Dulux Epoxy Thinner (920-08925) can be added to ease application. When brushing and rolling additional coats may be required to attain the specified thickness.
Conventional Spray	Thinning is not normally required, however, up to 50ml/litre of Dulux Epoxy Thinner (920-08925) can be added to ease application. Ensure paint is regularly agitated during application to prevent separation. Typical Set-up Graco Delta Gun: 1.8mm (239543) Pressure at Pot: 70-105 kPa (10-15 p.s.i.) Pressure at Gun: 380-415 kPa (55-60 p.s.i.)
Airless Spray	Standard airless spray equipment such as a Graco 33:1 Bulldog or 45:1 Xtreme with a fluid tip of 15-17 thou (0.38-0.43mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Ensure paint is regularly agitated during application to prevent separation. Thinning is not normally required but up to 50 ml/litre of Dulux Epoxy Thinner (920-08925) may be added to ease application.
Precautions	This is an industrial product designed for use by experienced Protective Coating applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux Representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express written consent of Dulux Australia. Freshly mixed material must not be added to material that has been mixed for some time. The rate of cure is dependent upon temperature. Do not apply at temperatures below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. When used for immersion conditions the maximum overcoat interval is 3 days at 25°C. The coating MUST be fully cured and solvent free prior to being placed under immersion conditions. For best results in water immersion conditions replace Dulux Epoxy Thinner (920-08925) with CR Reducer (965-63020). Topcoats of a saponifiable nature such as alkyds must never be applied directly to ZINCANODE402.
Clean Up	Clean all equipment with Dulux Epoxy Thinner (920-08925) immediately after use.

Overcoating

Aged coating should be tested for lifting by a method appropriate for the coating thickness, for example 'X' cut or cross-hatch methods. If it lifts, remove it. The surface must be free of oil, grease and other contaminants. High pressure water wash at 8.3 to 10.3 MPa (1,200- 1,500 p.s.i.) to remove loosely adhering chalk and dust.

Health And Safety	
Safety Precautions	Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers. Contents of container may be under pressure. Containers should be carefully opened by first placing a rag, then a hand, over the lid then gently easing the lid off.
Storage	Store as required for a flammable liquid Class 3 in a bunded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.
Handling	As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.
Using	Use with good ventilation and avoid inhalation of spray mists and fumes. If risk of inhalation of spray mists exists, wear combined organic vapour/particulate respirator. When spray painting, users should comply with the provisions of the respective State Spray Painting Regulations.
Flammability	This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO2 or dry chemical powder. On burning will emit toxic fumes.
Welding	Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.
Safety Data Sheet	MATERIAL SAFETY DATA SHEET is available from Customer Service (132377) or www.duluxprotectivecoatings.com.au
In the case of emergency, please call 1800 033 111	

Transport And Storage			
Packaging	Available in 4 litre and 10 litre packs	Transportation	2.12 kg/litre (Average of components)
Dangerous Goods Part A			
Class	3	UN Number	1263
Dangerous Goods Part B			
Class	3	UN Number	1263

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